

**SPECIFICATION AMENDMENTS**

Page 6, replace the paragraph beginning at line 24 with the following new paragraph:

--A preferred embodiment of the invention is generally shown in Figure 1 where a casting station comprises a molten metal feed trough 10, a casting mould 11 and a demountable metal transfer segment 12 between the trough and mould. The continuous casting operation per se and the moulds used for this purpose do not constitute a significant part of the present invention and, therefore, no detailed discussion of the same will be given. It will, of course, be understood that the emerging and continuously cast billets will be sufficiently solidified by the time they encounter downstream treatments that the physical structure or surface quality characteristics of the cast metal billets will not be adversely affected. Suitable casting moulds are more fully described in co-pending application Serial No. 10/735,076 filed December 11, 2003 (~~Attorney's Docket No. 71743 CCD~~), entitled "Horizontal Continuous Casting of Metals", assigned to the same assignee as the present invention, the disclosure of which is incorporated herein by reference and suitable metal feed troughs and transfer sections are more fully described in co-pending application Serial No. 10/735,075 filed December 11, 2003 (~~Attorney's Docket No. 71746 CCD~~), entitled "Heated Trough for Molten Metal", assigned to the same assignee as the present invention, the disclosure of which is incorporated herein by reference.--

Page 11, replace the paragraph beginning at line 13 with the following new paragraph:

--The cutting operation may be understood by reference to the schematic in Figure 11 and the flow chart in Figure 12. The first conveyor 13 is used to extract the cast billet 20 from the mould and the speed is set at a target speed based on the casting

practice for a particular alloy and mould. One of the roller clamps 26 that holds the billet 20 against the first conveyor includes an a speed encoder of conventional design and the measured speed from this encoder is compared to the speed of the ~~conveyer~~ conveyor 13 drive. In the event that the roller speed is less than the ~~conveyer~~ conveyor speed, it is assumed that the ingot is "slipping" on the conveyor and a rapid shutdown sequence may be initiated as more fully described in co-pending application Serial No. 10/735,074 filed December 11, 2003 (~~Attorney's Docket No. 71742 EED~~), entitled "Method and Apparatus for Starting and Stopping a Horizontal Casting Machine", assigned to the same assignee as the present invention, the disclosure of which is incorporated herein by reference.--